

Work Order ID 51901

Wednesday, September 09, 2009 11:04:18 A



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-9-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

0.00

802/10/13

[Signature] BG 09/10/13

B51901

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end								
	2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.								
	3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.								
	4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"								
	5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	8-Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R□□□ Aluminum Rod □								
	10-Grind welds flush as per Dwg D2750								

BE 09/09/17

09/09/28 ①

BE 09/09/17

DP 9-9-28

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Item ID: D350-636-011

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Revision ID: F

Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

> Scribe 9/28



130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

> Scribe 9/28



140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00



09

09

28

(1)

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Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9-9-25

Work Order ID 51901

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Item ID: D350-636-011

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Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex²291 batch: ☐☐☐
exp. date: 10-2-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: ~~410~~ M111999

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

9-9-28

M112391 AWM 9-9-27

PD 09-09-30

9-10-05 AWM

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Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

=> 80d/06

(X)

/

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 80d/06

(X)

/

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 11/09/07

(X)

/

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Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

M117260
Memo
START TIME: 11:25
OVEN TEMPERATURE: 320°
FINISH TIME: 11:55

0.00

BR 09-10 - 7

(D)

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo
Inspect for foreign object per QSI 024

0.00

MF 09/10/08

(X1)

Ø

220

HandFinishing

0.00



HandFinish

Hand Finishing

Memo
1- Install inserts as per Dwg D2750

0.00

MF 09/10/08

(VT)

Ø

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



HandFinish

Hand Finishing

HandFinishing

Memo

✓ Inspect for Foreign Objects

X 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241

✓ BATCH: 11112391
EXP DATE: 10/20

✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 1101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: 1104251

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 8/9/10/08

⇒ 4/ 09/10/08 (XD) /

⇒ 8/9/10/08 (H) /

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Setup Start



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Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/8 DSD

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

2) S 07/10/13

④ 4

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

DEU G

109/10/14 ①

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Item ID: D350-636-011

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Revision ID: F

Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/18/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/14 JG

mf 09-10-14

Picklist Print

Wednesday, September 09, 2009 11:04:25 AM

Page 1

Work Order ID: 51901

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	50
44892	15
47488	35

D2600-3-BENTRevD1 Manufactured No



Extrusion Bent

D2743RevB Manufactured No



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG	50
50281	50

Main Warehouse

ST	244
44891	2
45555	177
48275	65

BE 09/09/17

250675 BE 09/09/17

AWM 9-9-29 (E)

Picklist Print

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Work Order ID: 51901



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

B-52305 AWM 9-7-28

AWM 9-9-29 (4)

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 51901

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3490-1RevA

Manufactured

No

160

Each

165.0000

4.0000



Cross Bolt Spacer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

165

45338

2

47118

4

47657

50

48277

109

ALS4-1032-225

Purchased

No

220

Each

8,753.000

38.0000



Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8753

107441

16

110768

8737

D3492-041RevC

Manufactured

No

230

Each

3.0000

8.0000



Plug Assembly

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

43816

3

AWM 9-9-29-4

x30 ul 09/10/09

x8 ul 09/10/09

Picklist Print

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Work Order ID: 51901

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA  Wearshoe		Manufactured	No			230	Each	22.0000	1.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 22

47720 11

50216 11

AN8C35A



BOLT

Purchased

No

230

Each

167.0000

1.0000



X1 21 09/10/09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 167

102180 1

106896 1

110105 65

110847 100

X1 21 09/10/09

Picklist Print

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Work Order ID: 51901

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

B51906

X1 48 09/10/08

40551

18

47537

1

50231

4

13

D3488-041RevB

Manufactured

No

230

Each

29.0000

1.0000



Blade Fitting Assembly, LH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

41853

1

44530

8

47348

20

X1 48 09/10/08

Picklist Print

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Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA		Manufactured	No			230	Each	27.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	27	
46531	2	
47440	2	
47722	11	
50240	12	

AN6C44A

Purchased

No

230

Each

172.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG	2	
103964	2	

Main Warehouse

ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

x1 41 09/10/08

11112720

x1 41 09/10/08

Picklist Print

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Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	90.0000	1.0000			
NUT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	90	
110584	5	
111424	2	
111637	21	
112243	42	
112492	20	

X 1 09/10/09

D3536-25RevA

Manufactured No



Gasket

X

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	21	
45569	1	
47011	2	
47526	8	
50266	10	

X 1 09/10/09

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Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA		Manufactured	No			230	Each	105.0000	8.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B51908	
ST	105	
38139	6	
45353	16	
47437	83	

x8 41 09/10/08

D3791-1RevA

Manufactured No

230

Each

18.0000

1.0000



Wearplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
47536	8	
50269	10	

x1 41 09/10/08

Picklist Print

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Parent Item Name: Skidtube LH



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	7,340.000	38.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	7284	
112116	2284	
112612	5000	

x 38 W/ 09/10/08

Picklist Print

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Parent Item Name: Skidtube LH


Start Date: 9/10/2009

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB 		Manufactured	No			230	Each	272.0000	8.0000			
Bushing												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
45556	69
46695	18
48278	110

AN3C5A

Purchased

No

230

Each

642.0000

34.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	642
111424	8
111707	334
112314	200
112489	100

M112720

[Handwritten signature]

x34

09/10/08

Picklist Print

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC Wearpad		Manufactured	No			230	Each	45.0000	3.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		B51910
FP	45	
48288	2	
50321	43	

x3 y1 09/10/08

AN960C816L



WASHER

Purchased

No

230

Each

330.0000

1.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

x1 y1 09/10/08

D3492-043RevC



Plug Assembly

Manufactured

No

230

Each

0.0000

8.0000

B51642

x5 y1 09/10/08

Wednesday, September 09, 2009 11:04:25 AM

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Page 11

Picklist Print

Page 12

Wednesday, September 09, 2009 11:04:25 AM

Work Order ID: 51901



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A 		Purchased	No			230	Each	1,048.000	4.0000			
BOLT												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1048

110372

72

111982

976

x4 41 09/10/09

NAS1611-013

Purchased

No

230

Each

320.0000

1.0000



O-RING

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

320

106513

11

111424

109

111758

200

x8 41 09/10/09

NAS1611-010

Purchased

No

230

Each

345.0000

1.0000



O-RING

X?

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

345

110715

50

110915

295

02594-3/1351613

x8 41 09/10/09

* PTO ~~last page~~ =>

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/08	N/A	Replace NAS1611-010 "O" Rings for D2594-3 "O" Rings	JH	09/10/08	X8		S 09/10/08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 09, 2009 11:04:25 AM

Work Order ID: 51901



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	11.0000	1.0000			
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47523

B51663

11

11

x1 09/10/08

D3794-1RevA

Manufactured No



Gasket

230

Each

33.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46530

47212

47721

51668

33

1

2

4

26

x1 09/10/08

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Wednesday, September 09, 2009 11:04:25 AM

Work Order ID: 51901



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6 		Purchased	No			230	Each	1,132.000	4.0000			
NUT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1132	
110584	34	
111424	98	
112314	1000	

XL JL 9/10/08

S

D3493-1RevA



Washer

Manufactured No

260 Each 115.0000 2.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	115	
44902	15	
47710	100	

47710 9/10/8 DSP

Picklist Print

Wednesday, September 09, 2009 11:04:25 AM

Work Order ID: 51901



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			260	Each	90.0000	2.0000			
NUT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	90	
110584	5	
111424	2	
111637	21	
112243	42	
112492	20	

112243 SP

AN8C21A

Purchased

No

260

Each

110.0000 2.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	110	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
111684	50	

111684 9/10/8 SP

Picklist Print

Wednesday, September 09, 2009 11:04:25 AM

Work Order ID: 51901

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L WASHER		Purchased	No			260	Each	330.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424 SL

NAS1515H3L

Purchased

No

260

Each

350.0000

4.0000

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

SL 09/10/08

Picklist Print

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Work Order ID: 51901

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/18/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC		Manufactured	No			260	Each	40.0000	1.0000			
<div>  </div>												
Blade, 350 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	40	
20770	0	
45320	1	
47113	39	

47113 SP

D3532-1RevA

Manufactured No

260 Each 43.0000 2.0000



Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	43	
38161	2	
44904	41	

44904 9/10/8 SP

Picklist Print

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Wednesday, September 09, 2009 11:04:26 AM

Work Order ID: 51901



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L  WASHER		Purchased	No			260	Each	127.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	127	
107581	34	
108964	1	
111650	92	

111650 *sd 9/10/09*

8' 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018, UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

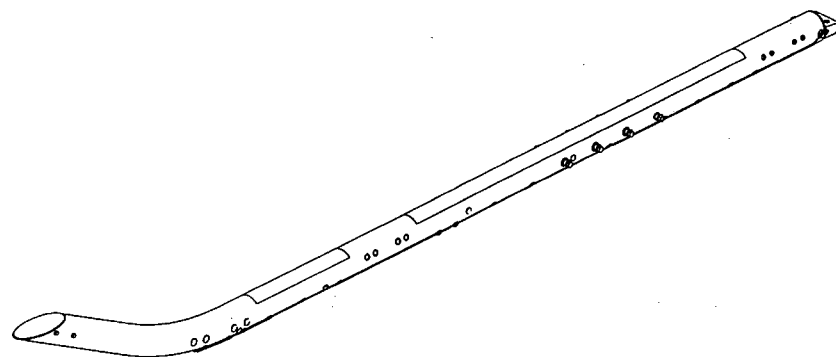
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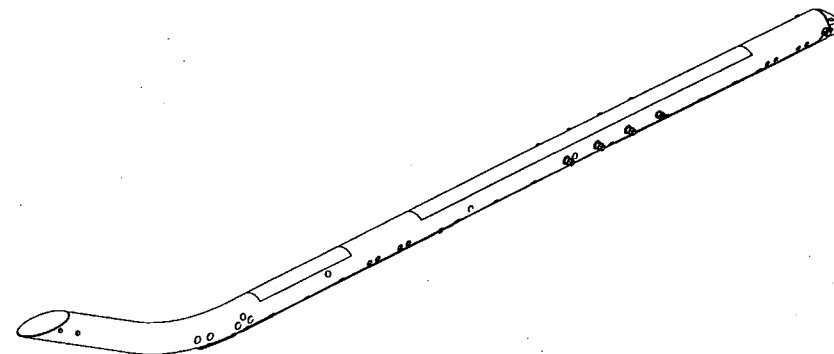
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	RAH	DRAWING NO.	REV. F
MFG. APPR.	RAH	D2750	SHEET 1 OF 11
APPROVED	RAH	TITLE	SCALE
DE APPR.	RAH	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

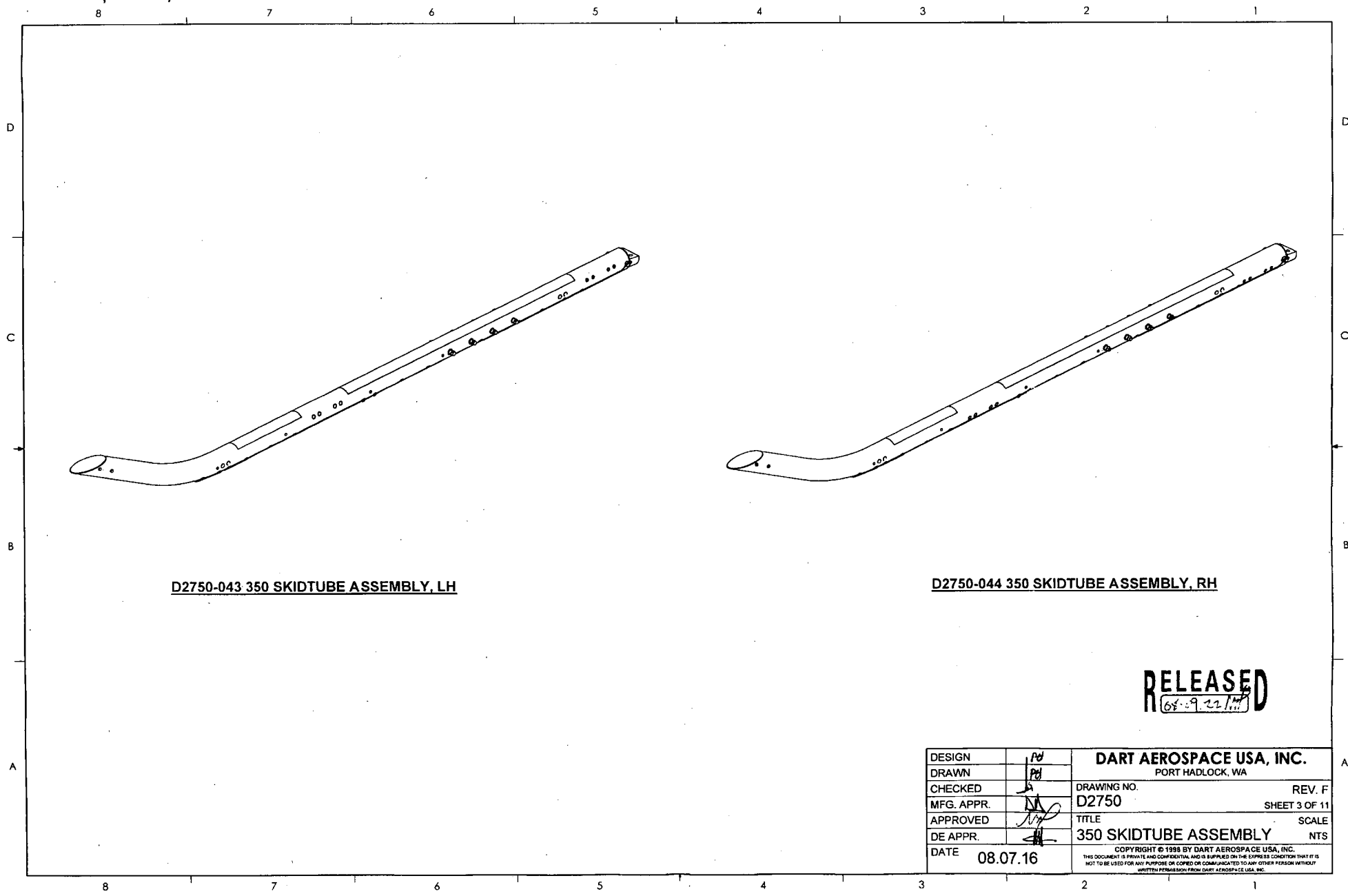


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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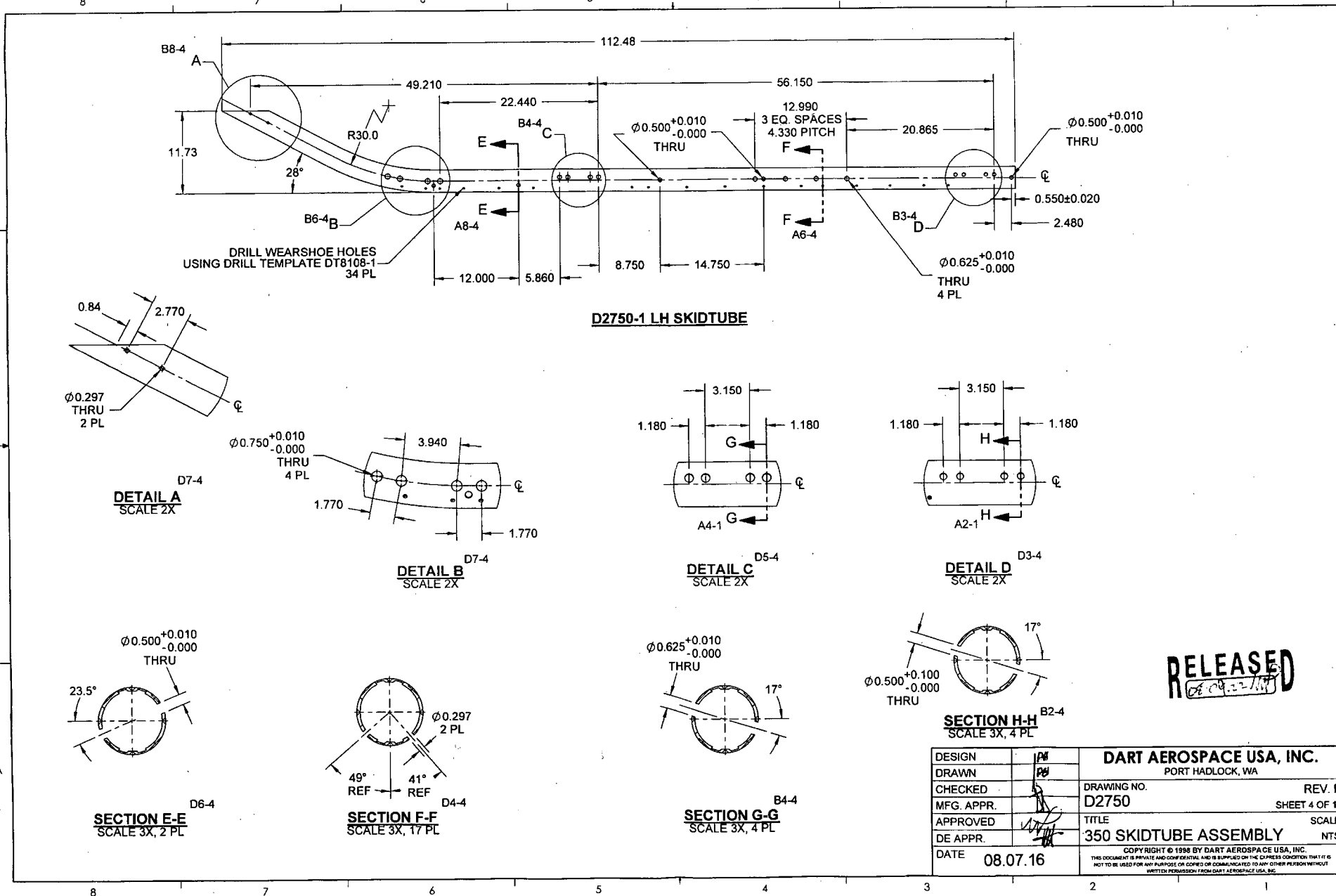
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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D2750-2 RH SKIDTUBE

DRILL WEARSHOE HOLES USING DRILL TEMPLATE DT8108-1 34 PL

DETAIL J
SCALE 2X
D8-5

DETAIL K
SCALE 2X
C7-5

DETAIL L
SCALE 2X
D6-5

DETAIL M
SCALE 2X
C3-5

SECTION N-N
SCALE 3X, 2 PL
C6-5

SECTION P-P
SCALE 3X, 17 PL
C4-5

SECTION Q-Q
SCALE 3X, 4 PL
B5-5

SECTION R-R
SCALE 3X, 4 PL
B3-5

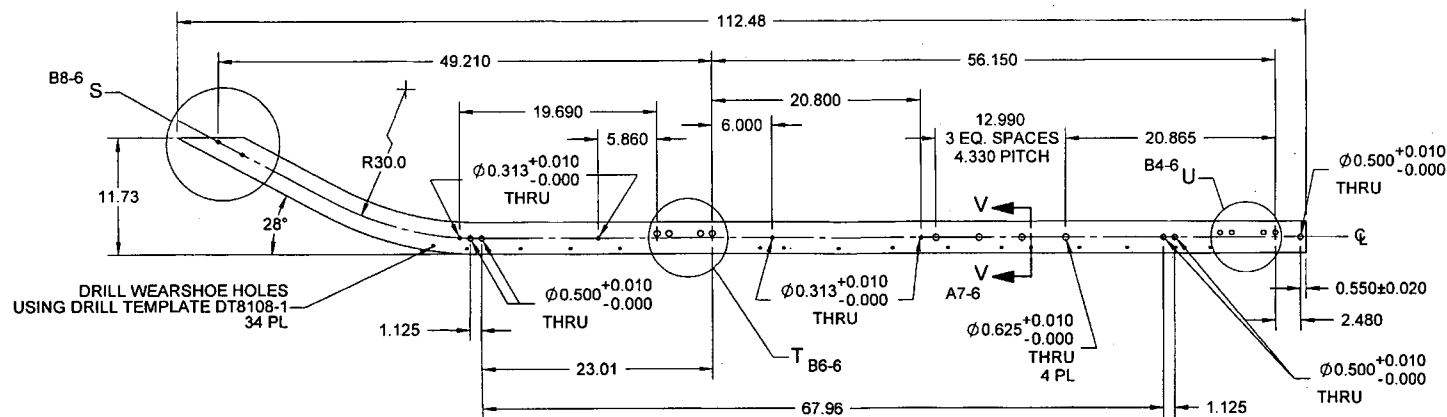
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		REV. F
		SHEET 5 OF 11
		SCALE
		NTS

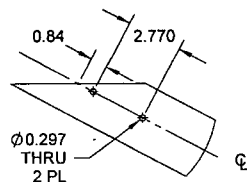
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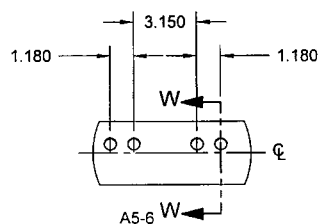
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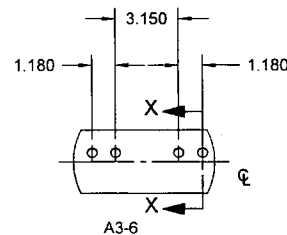
D2750-3 LH SKIDTUBE



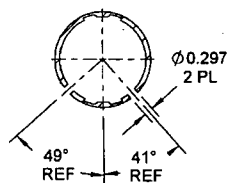
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SCALE 2X



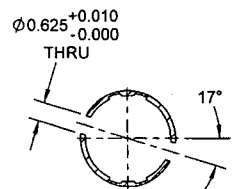
DETAIL T
SCALE 2X



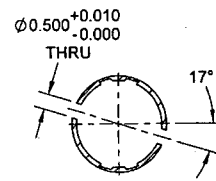
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



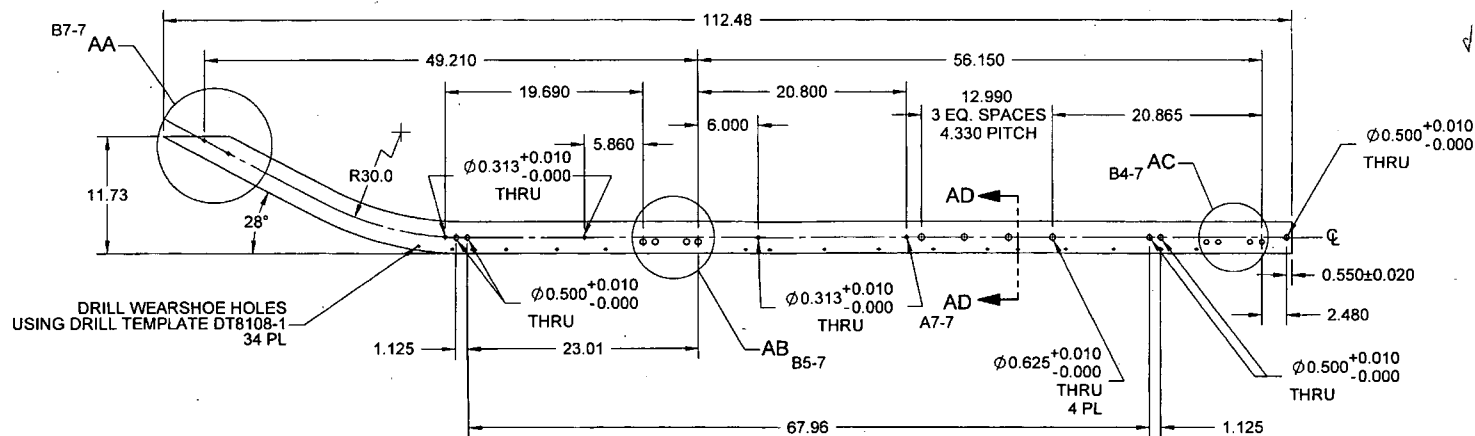
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SCALE 3X, 4 PL

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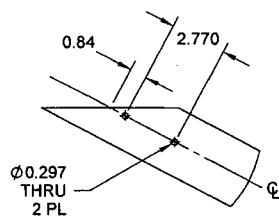
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MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

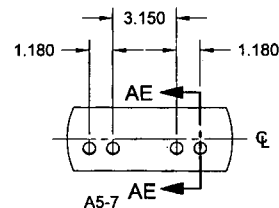
u/o 51901



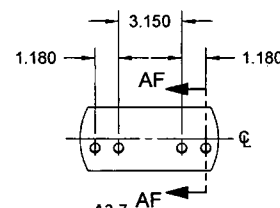
D2750-4 RH SKIDTUBE



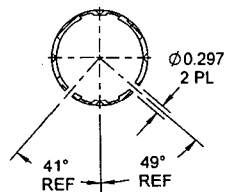
DETAIL AA
SCALE 2X



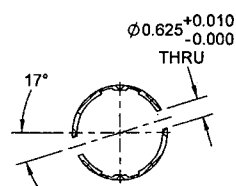
DETAIL AB
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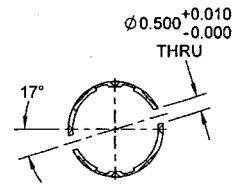
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

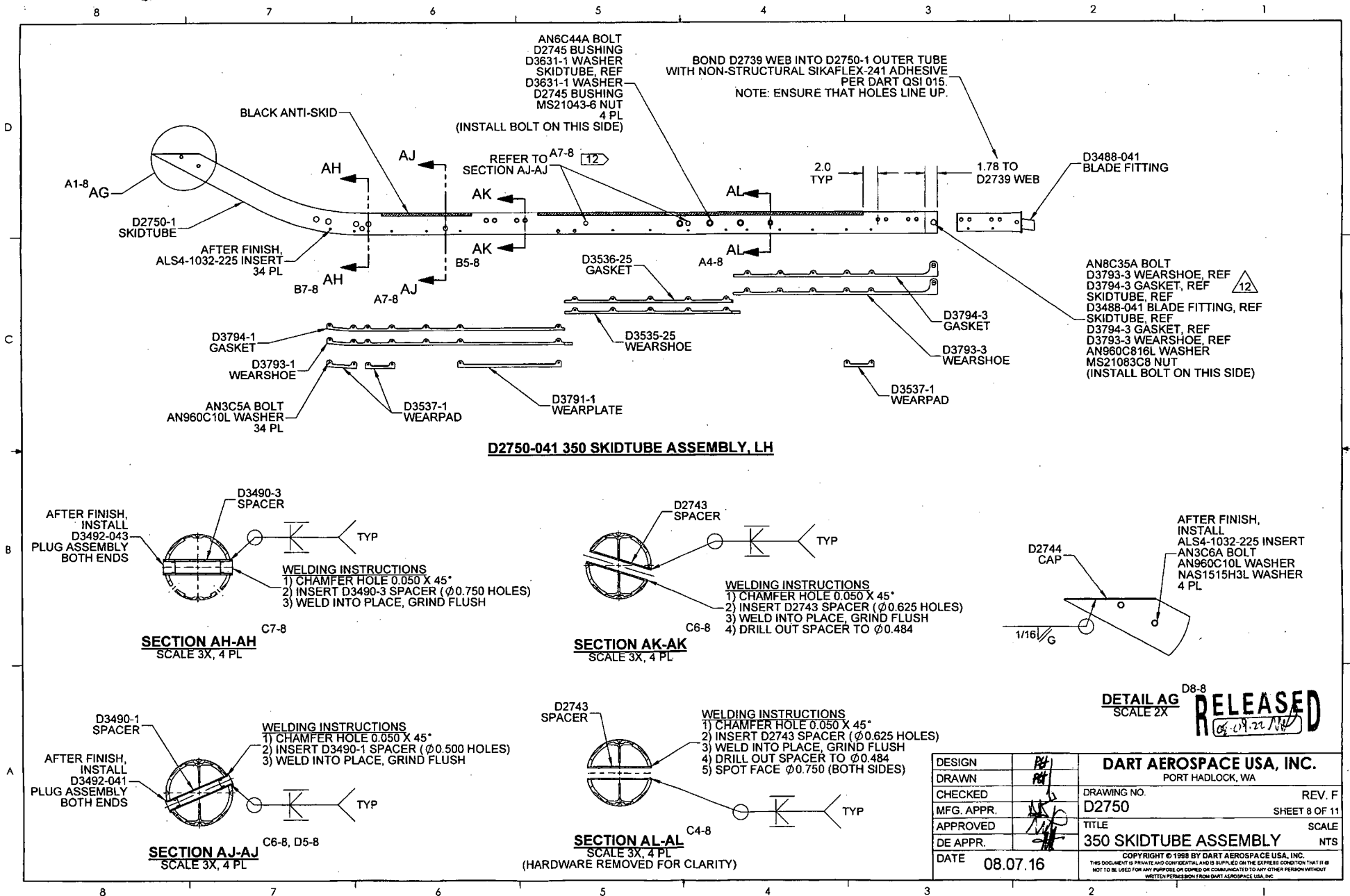


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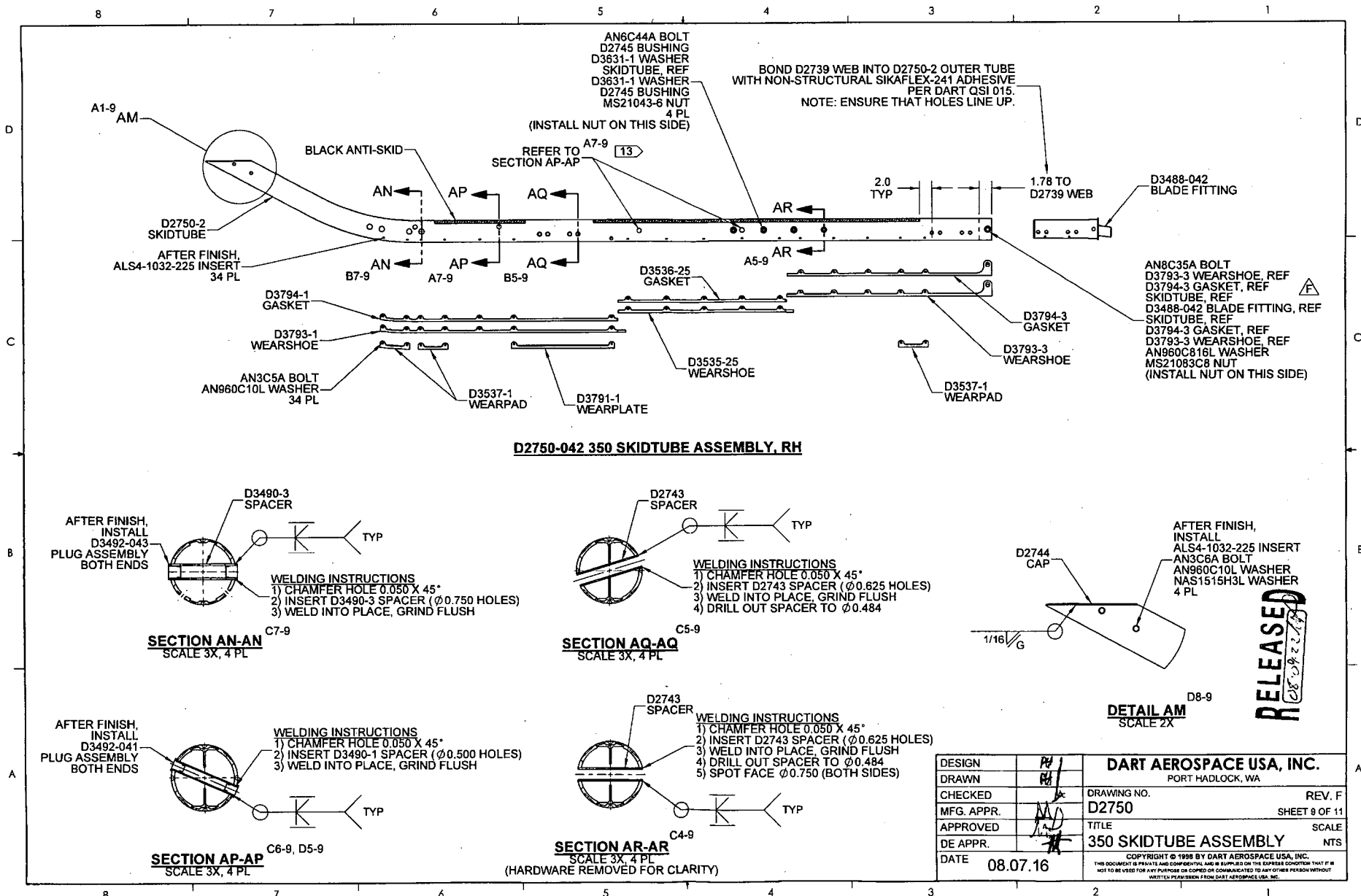
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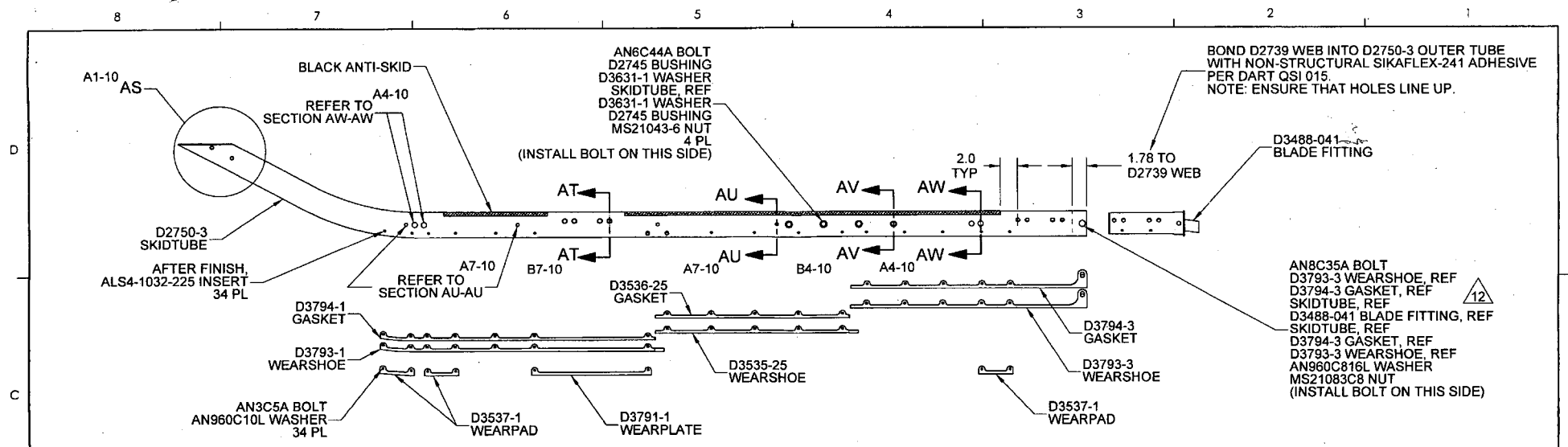
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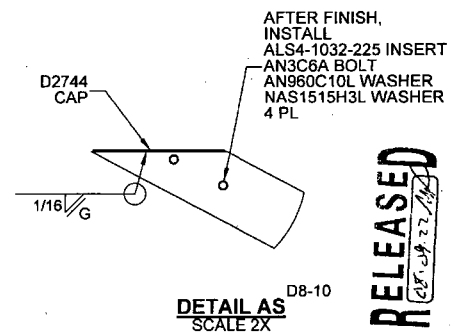
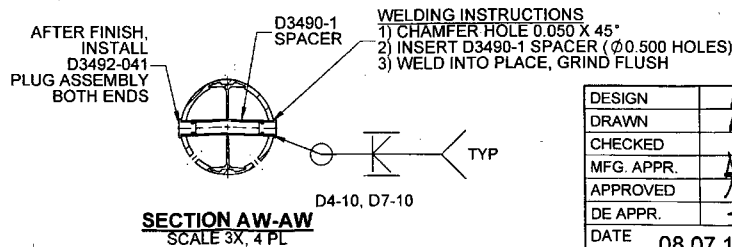
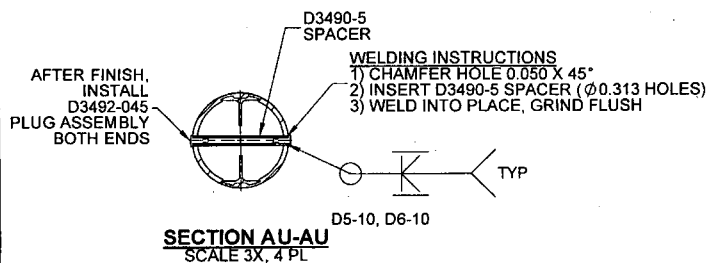
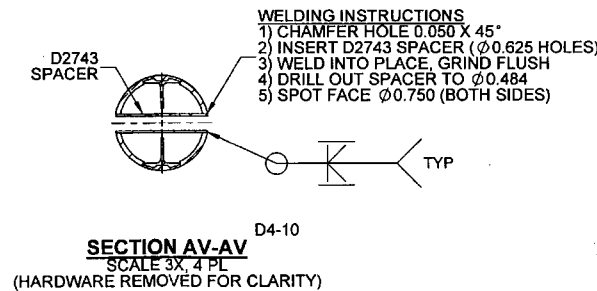
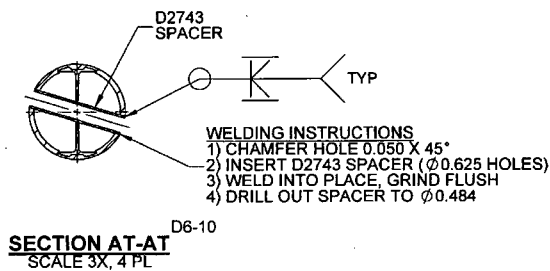
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W/O 31901



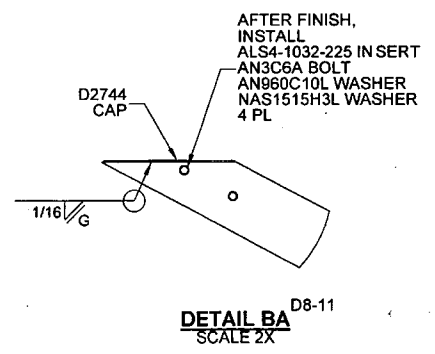
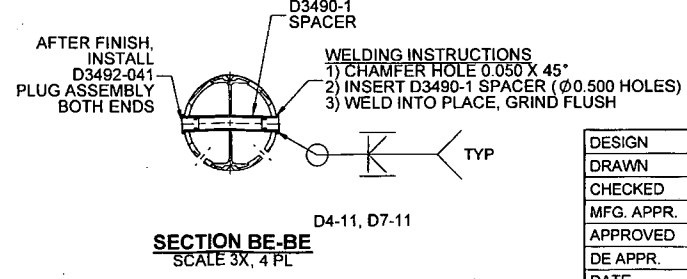
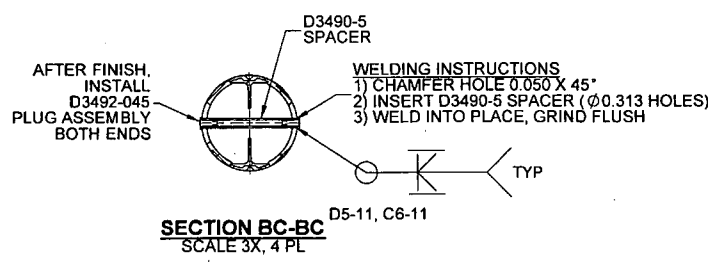
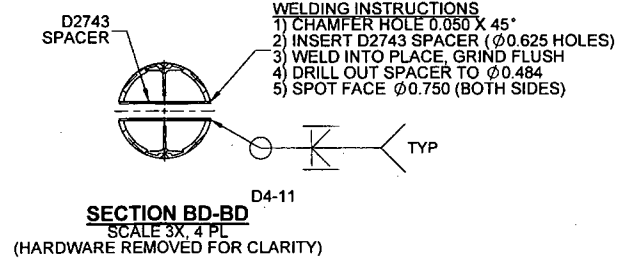
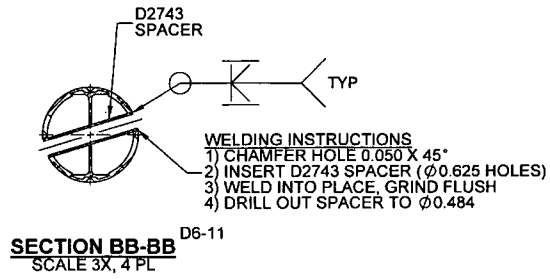
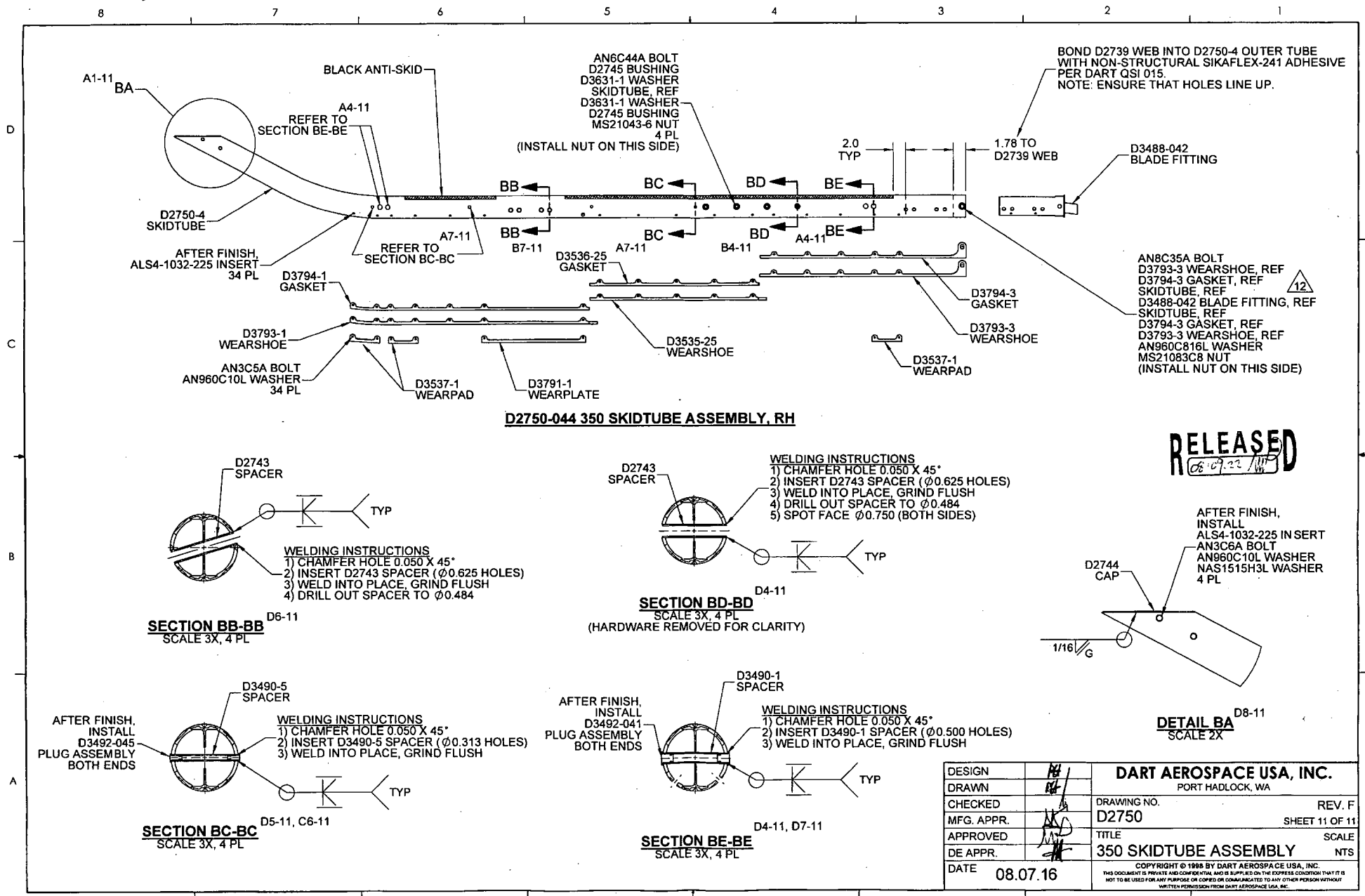
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NO. 209

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: A. R. Auer
Job number: 51803
Part number: A350-636-011
Description: 350 Skottube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Daniel Auer Date of Test Coupon 06/09/28
Welder A. R. Auer Date of Test Coupon 09.09.28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld